

ASAP ship Monday 12/est. 20/09

Dart Aerospace Ltd.

Date: Thursday, 02/04/2009 2:26:26 PM
User: Julie Dawson

Process Sheet

Spit

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : LUG ASSEMBLY |
| Job Number : 46862-2 | |
| Estimate Number : 10911 | |
| P.O. Number : | Part Number : D3405041 |
| This Issue : 02/04/2009 S.O. No. : | Drawing Number : D3405 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : LARGE FAB ASSY | Drawing Revision : B |
| Previous Run : 46071 | Material : |
| Written By : | Due Date : 17/04/2009 Qty: 20 Um: Each |
| Checked & Approved By : JUD 09-04-02 | |
| Comment : Est A 05.09.01 New issue KJ/JLM | |
| Est B 09.01.28 rev.B drawing EC verified by:DD | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-----------|---------------------|
| 1.0 | M304S11GA | 304/316 0.125 Sheet |
|-----|-----------|---------------------|



Comment: Qty.: 0.1617 sf(s)/Unit Total : 3.2340 sf(s)
304/316 .125 Sheet
(M304S11GA)
Batch: 111018 B 9-4-15

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
1-Cut as per Dwg D3405
Dwg Rev: B
Prog Rev: B

B 9-4-15

(28)

2-Deburr if necessary B 9-4-15

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

508/04/16 counter (428)

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE
Deburr
Form using DT8204 as per Dwg D3405

B 09/04/17 (12)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 46862

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SOS 04/17 (X12)

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

GHW Lug

Pick:

Qty Part number

Description

Batch

1 D3404-1

Lug

A/R

SS Rod

B46697
N 9676

EL 9-4-17 x12

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-041

EL 9-4-17 x12

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-04-17 (12)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SOS 04-17 (12)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 M 110959

START TIME:

9:30

OVEN TEMPERATURE:

375°

FINISH TIME:

10:00

BR 09-04-20 (12)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-20

(X12)



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 46862

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



(12x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 719

9/4/20

SP

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

209/04/20

Job Completion



11 09-24-20



B

1

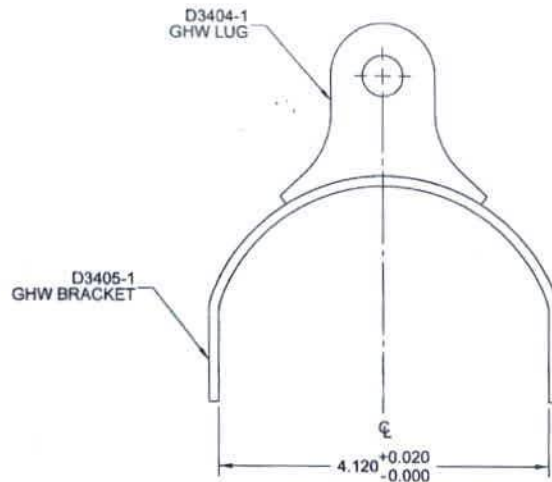
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08/12/18 MP

NO 1080

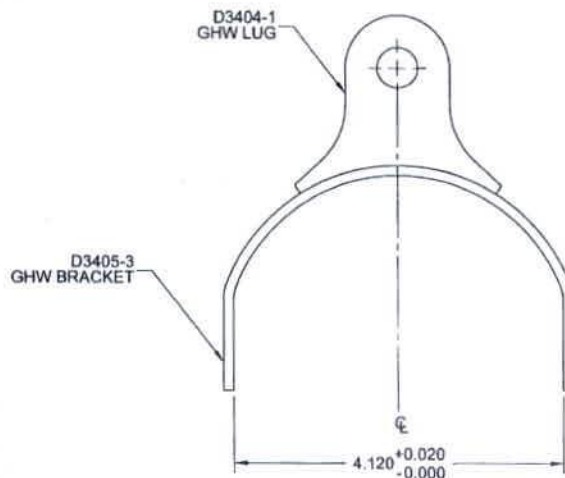
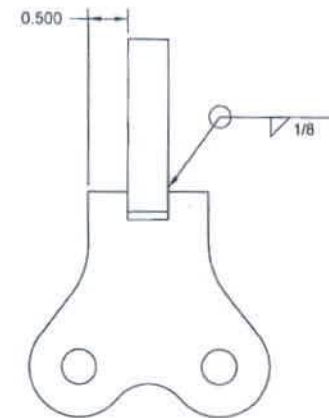
A

- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

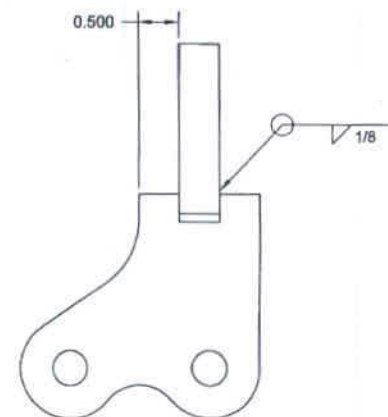
| | | | | |
|------------|---|---|--------------|----------|
| B | DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4 120 DIM WAS 4 100. | | AJS | 08.09.19 |
| A | NEW ISSUE | | PH | 05.03.08 |
| REV | DESCRIPTION | | BY | DATE |
| DESIGN | PH | DART AEROSPACE LTD | | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED |  | DRAWING NO. | REV. B | |
| MFG. APPR. | | D3405 | SHEET 1 OF 1 | |
| APPROVED | | TITLE | SCALE | |
| DE APPR. | | GHW LUG ASSEMBLY | NTS | |
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D3405-041 LUG ASSEMBLY



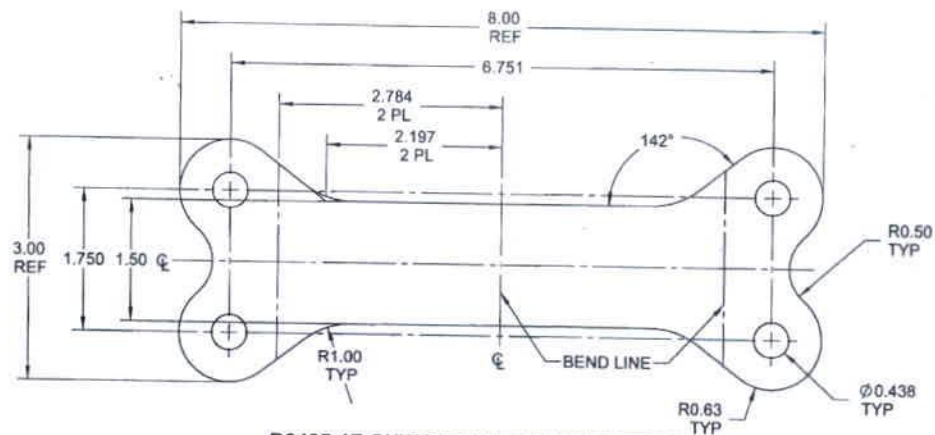
D3405-043 LUG ASSEMBLY



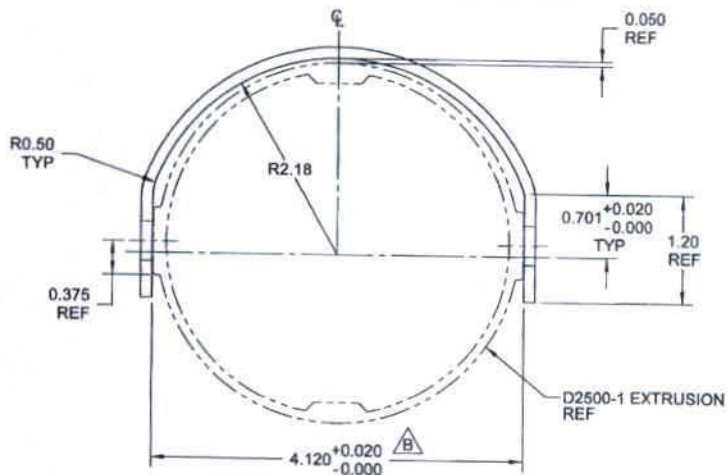
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6/12/18

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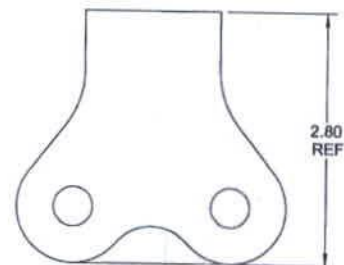
| | | | |
|--|---|-----------------------------|--------|
| DESIGN | PH | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. D3405 | REV. B |
| MFG. APPR. |  | SHEET 2 OF 4 | |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | GHW LUG ASSEMBLY | |
| DATE | 08.09.19 | NTS | |
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D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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RELEASED
08/09/19

| | | | |
|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | ABS | | |
| CHECKED | | DRAWING NO. D3405 | REV. B |
| MFG. APPR. | | | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | GHW LUG ASSEMBLY | NTS |
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